

Date: Wednesday, 02/04/2008 11:27:06 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	6" MIRROR
Job Number :	38288		
Estimate Number :	10101		
P.O. Number :		Part Number :	D2011101
This Issue :	02/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2011 REV. F
First Issue :	//	Project Number :	N/A
Previous Run :	37326	Drawing Revision :	F
	Type :	Material :	
	SMALL /MED FAB	Due Date :	11/04/2008
Written By :		Qty:	50
		Um:	Each
Checked & Approved By :	JD 08.04.02		
Comment :	Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6054
 Purchase Grote Mirror P/N: 28043
 Possible supplier: UAP/NAPA
 Material release note required

c 208/04/02
 (50)

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

208/03 (50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

208/04/05 (50)

5.0	D30141	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 Locknut

Pick:

Qty	Part Number	Description	Batch
1	D3014-1	Lock nut	618605

✓

ml 08/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 38288

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer M107008

✓

ml 08/04/07

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch

9ml N/A Sikaflex-291/-241 M105585

Expiry date 10/2008

Start: 08/04/07 Time: 10:30 AM

Finish: 10:30 AM

ml 08/04/07

8.0

QC5

8/4/07

8:00 AM

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

8/04/07 (XSD)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 027

8/4/07

SP

(50X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/07

Job Completion



mf

08-04-09

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

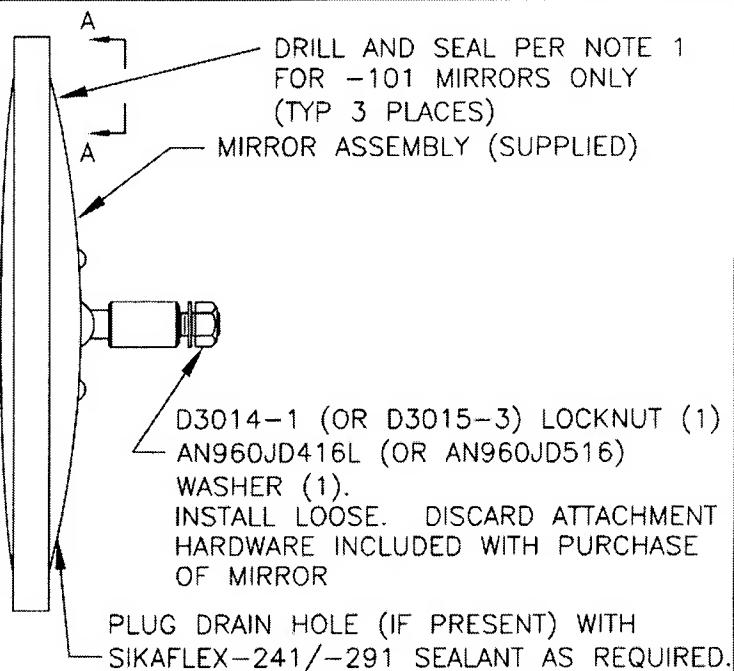
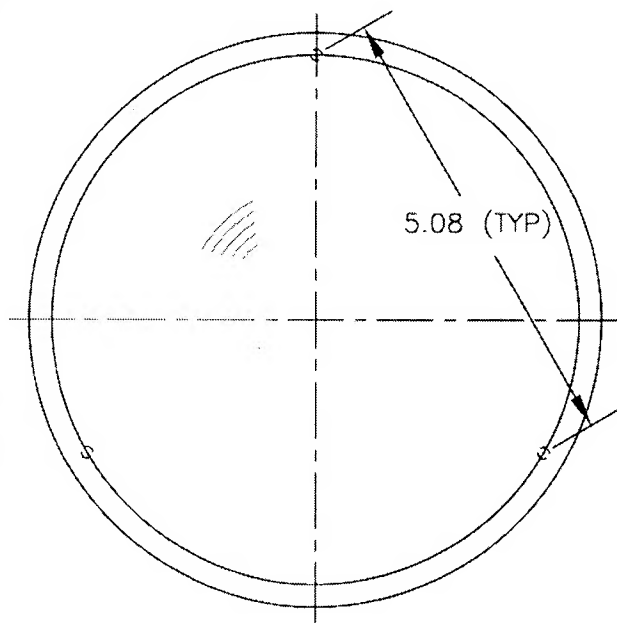
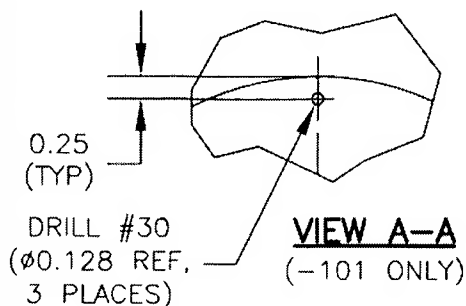
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10	TITLE MIRROR ASSEMBLY		SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38288

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04.09.10



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Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

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TERMES: Compte payable le 10 du mois suivant.

SIGNATURE _____

GST / TPS
10035 3366 RT0001

1000 RUE LANDSDOWNE
TEL: (613)632-1191

HAWKESBURY, ON K6A 1H7
FAX: (613)632-2350

TVQ
1016330716 TO0001

Pour chaque tranche d'achat de \$200 de produits Walter entre le 15 mars et le 15 avril>>> une chance de gagner une TV a ecran plat 32". Contactez votre Rep.

113336 (613)632-5200
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T O A HAWKESBURY ON K6A 1K7

EXP
SHIP
DIER
TO
A

113336

*** SAME ***

DATE: 4/03/08
08:56
111 M/LP

PO: 0000-6054

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION
10	50	038	28043	6" CONVEX ASSEMBLY	43.09	15.60	730.00
	50	***	direct grote	PIECES/CORE TOT	0.00		0.00
			SHIP VIA	REGULAR			
INVOICE No / FACTURE	TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT to PAY / À PAYER
10366734	INVOICE	730.00	0.00	0.00	39.00	0.00	819.00